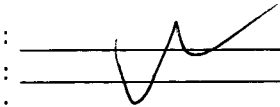
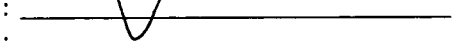


Date: Tuesday, 18/12/2007 1:29:56 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3183-041
Job Number : 36430	
Estimate Number : 10804	
P.O. Number :	Part Number : D31831
This Issue : 18/12/2007 S.O. No. :	Drawing Number : DISASSEMBLE
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 25/12/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

1 X D3183-041 B21893

u 07.12.18

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

DISASSEMBLE & RESTOCK:

1 X D3183-1 21893

1 X D3183-5 21884

DISCARD :

D3121-21 23459

D3183-9 23505

1x D3183-5 21884

u 07.12.18

u 07.12.18

3.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.12.18

1- 5/23

DART AEROSPACE LTD	Work Order:	23505
Description: Bearing Assembly	Part Number:	D3183-045
Dwg: D3183 Rev. C	Qty:	32 Kit(s)
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	DA	05.06.03	32
2	MC	Turn D3183-9 Cap as per Folio FA388 Material: Ø1.00 Delrin Rod (M-DELRIN-RT.000) Identify as <u>D3183-9</u> Batch: <u>B21875B</u>	BC	05/06/03	32
3	MC	Deburr	N/A		
4	QC2	Inspect parts as they come off the CNC machine	N/A		
5	QC8	Second check	N/A		
6	GA	Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183. Pick: Qty Part Number Description Batch 1 D3183-5 Bearing <u>1321884</u> Identify as D3183-045	EP	05/06/03	32
7	QC5	Inspect work to Step 6	RE	05.06.06	32
8	ST	Identify and Stock	CL	05/06/06	32
9	AC	Cost / part 7.07	AP	05/06/07	32
10	DC	Close W/O 6.43 Inspect Level 21	DA	05.06.08	32

Rev	Date	Change	Revised By	Approved
A	04.02.18	New issue	KJ/DS	#

RELEASED
04.02.14

148

109.02

3

DART AEROSPACE LTD		Work Order:	21893
Description: Bracket Assembly		Part Number:	D3183-041
04.11.25 C1 04.02.1918			D3183-042
Dwg: D3183 Rev. A page 1, 2, 4		Qty:	5 Kits
03.10.02			Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	FA	04.11.26	5
2	MV	Cut (1) blank per D3183-041 & (1) blank per D3183-042 Cut blanks (2.00" x 1.50") x 4.30" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B2.000x01.500) Batch: M14773	En	05.06.06	5
3	MV	Machine D3183-1 as per Folio FA320 and Dwg D3183	En	05.06.07	5
4	QC2	Inspect parts as they come off the CNC machine	En	05.06.07	5
5	MV	Machine D3183-2 as per Folio FA320 and Dwg D3183	En	05.06.06	5
6	QC2	Inspect parts as they come off the CNC machine	En	05.06.06	5
7	MV	Deburr Break all sharp edges 0.005 to 0.015	En	05.06.06	5
8	MV	Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183	En	05.06.06	5
9	QC5	Second check D3183-1 and D3183-2	SD	05.06.06	5
10	GA	Assemble D3183-041 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 23505 4 D3183-8-045 Bearing 23505 2 D3183-7 Washer 2 MS24694-S50 Screw 2 B121-21 Bolt 23513	En	05.06.06	5
11	GA	Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 23505 4 D3183-8-045 Bearing 23505 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D3121-21 Bolt B23459B	En	05.06.06	5
12	QC5	Inspect work to Step 10 & 11	En	05.06.07	5
13	ST	Identify and Stock in Spacedoor cell D3183-041 Qty 5 D3183-042 Qty 5	En	05.06.07	5
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 94.25 94.25	En	05.06.13	5
15	DC	Close W/O 136.01 139.34 Inspect Level 21	En	05.06.15	5

Rev	Date	Change	Revised By	Approved
A	03.03.28	New issue	KJ/RF	FA

RELEASED
03.03.11